

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021513**Date Inspected:** 07-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

The Quality Assurance (QA) Inspector, Rick Bettencourt was on site at the job site between the times noted above.

The QA Inspector was on site to randomly observe the in process welding and inspection of the weld joints identified as 10W/11W and the lifting lug holes identified below the following observations were made:

10W/11W

The QA Inspector arrived on site to observe the OBG lift identified as 11W was on site at the bridge and setting on the trestle. The QA Inspector noted 11W was not pushed all the way into 10W rather setting approximately 1 meter away. The QA Inspector randomly observed the ABF personnel performing grinding and blending under the top deck plate. The QA Inspector noted the ABF representatives were transitioning and removing weld reinforcement to allow the steel backing bar to fit up with intimate contact to the top deck plate. The QA Inspector randomly observed the same process being performed on the bevel face of the weld joint of both lifts 10W and 11W to remove paint from the bevel face in preparation of welding. The QA Inspector noted the two above lifts were pushed closer together on this date but not the entire way. The QA Inspector noted a gap of approximately 100mm at the end of the QA Inspector shift.

For the remainder of the QA Inspectors shift, the Lead QA Inspector Rick Bettencourt performed QA ultrasonic testing (UT) verification of the lifting lug hole weld joints identified below that were previously turned over by the SE QC Inspector Bonifacio Daquinag. The QA Inspector performed approximately 10% UT and VT verification of the weld joints and noted no rejectable indications were located at the time of the testing (see TL-6027 for 3.07.11):

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2W-pp17-W3-1,2
3W-pp20-W4-1,3,4
3W-pp22-W4-2,3,4
6E-pp40-E3-1,2,3,4
6E-pp44-E3-1,2,3,4
7E-pp52-E4-1,2,3,4

The QA Inspector spent the remainder of the shift walking the top deck inside and out of the East and West bridge decks. The QA Inspector took field notes of the status of the production welding, and or NDT of the lifting lug deck hole restorations. The QA Inspector later transferred the data collected in the field to on site excel spread sheets or tracking logs for future references.

Summary of Conversations:

The ABF Welding Superintendent Dan Ieraci informed the QA Inspector ABF is not planning to work anymore than 10 hours a day this week. Mr. Ieraci went on to inform the QA Inspector the long hours of the last deck splice is an anomaly due to the urgency of erecting the cross beams.

The QA Task Lead Bill Levell informed the QA Inspector RWR-201103-003 is approved at 1200 per Caltrans Structures Material Representative Nick Havass.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

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| Inspected By: | Bettencourt,Rick | Quality Assurance Inspector |
| Reviewed By: | Levell,Bill | QA Reviewer |
